

Date: Tuesday, 30/09/2008 8:54:15 AM  
 User: Julie Lecocq

## Process Sheet

|   |   |
|---|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services               | <b>Drawing Name</b> : HI-STEP LEG ASSEMBLY                  |
| <b>Job Number</b> : 42344   |   |
| <b>Estimate Number</b> : 10385                                      |   |
| <b>P.O. Number</b> :  | <b>Part Number</b> : D3065041                               |
| <b>This Issue</b> : 30/09/2008 <b>S.O. No.</b> :                    | <b>Drawing Number</b> : D3065 REV B                         |
| <b>Prsht Rev.</b> : NC  | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB               | <b>Drawing Revision</b> : B                                 |
| <b>Previous Run</b> : 41445   | <b>Material</b> :   |
| <b>Written By</b> :   | <b>Due Date</b> : 15/10/2008 <b>Qty:</b> 50 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JLD 08.9.30</u>               |   |
| <b>Comment</b> : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF |   |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation:   | Description :         |
|---------|---|-----------------------|
| 1.0     | 42344A  | STEP SPACER           |
|         |   |                       |
|         | <b>Comment:</b> Sub-Component STEP SPACER<br>1 x D3065-1 Batch <u>B42344</u>  |                       |
| 2.0     | 42344B  | STEP SPACER           |
|         |   |                       |
|         | <b>Comment:</b> Sub-Component STEP SPACER<br>1 x D3065-3 Batch <u>B41445</u>  |                       |
| 3.0     | 42344C  | STEP LEG              |
|         |   |                       |
|         | <b>Comment:</b> Sub-Component STEP LEG<br>2 x D3065-5 Batch <u>B41445C</u> (15x) <u>B42344</u> (85x) <u>B38650</u> (8x) <u>B39861</u> (42x)   |                       |
| 4.0     | 42344D  | STEP SPACER           |
|         |   |                       |
|         | <b>Comment:</b> Sub-Component STEP SPACER<br>1 x D3065-7 Batch <u>B38650</u> (8x) <u>B39861</u> (42x)   |                       |
| 5.0     | MS20470AD44   | Rivet, Universal Head |
|         |   |                       |
|         | <b>Comment:</b> Qty.: 30.0000 Each(s)/Unit Total : 1500.0000 Each(s)<br>Rivet, Universal Head<br>Pick:<br>Qty Part Number Description Batch<br>30 MS20470AD4-4 Rivet <u>M109545</u> |                       |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 30/09/2008 8:54:15 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 42344

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



MF 08-12-03

08/12/02 (50)  
counter  
08/12/02 (50)

SAD 08-12-03 (50)

08/12/03

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

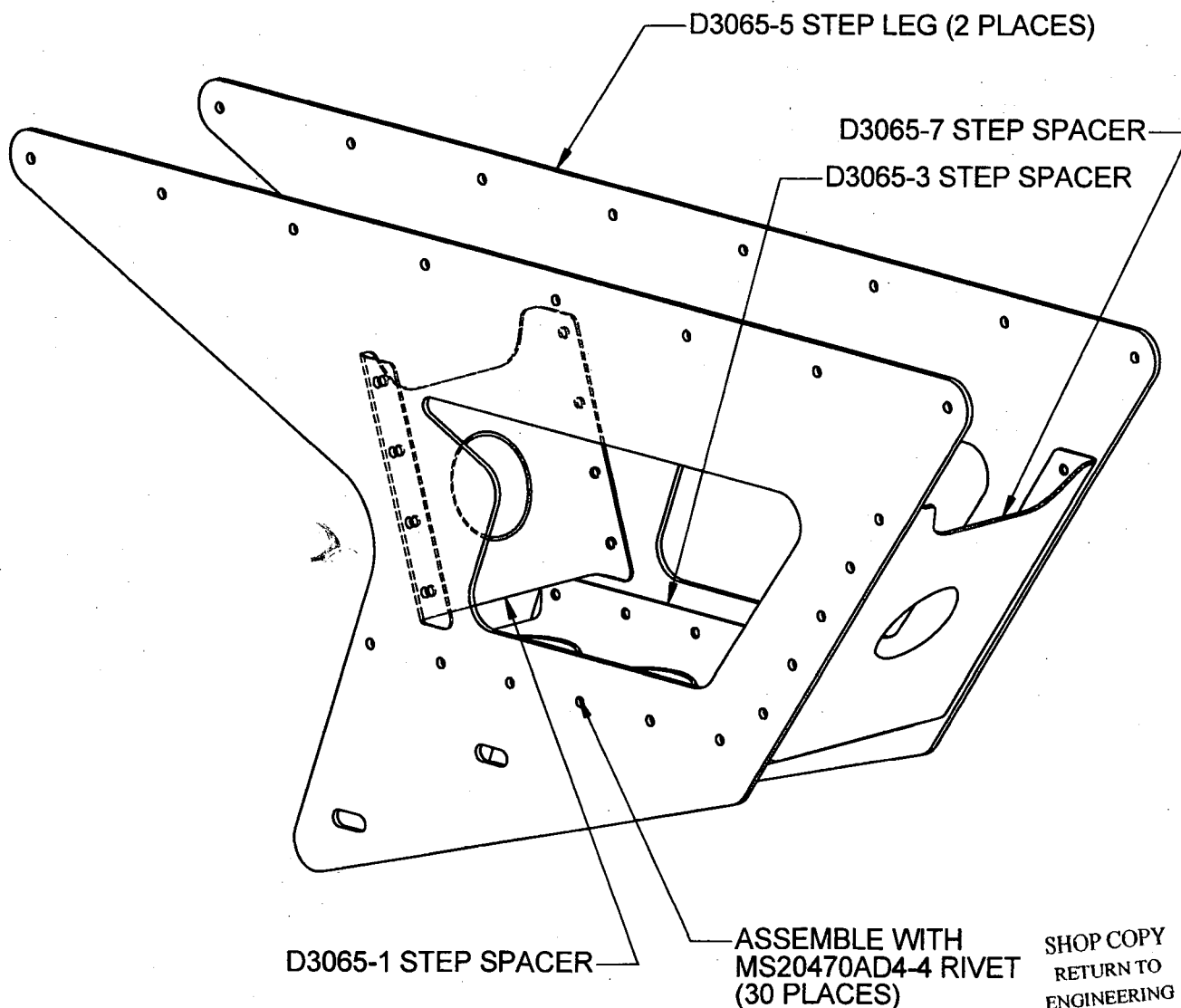
**NOTE:** Date & initial all entries

**DART**

|                         |                                |  |                        |
|-------------------------|--------------------------------|--|------------------------|
| DESIGN<br><i>CP</i>     | DRAWN BY<br><i>CB</i>          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i>    | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3065</b>                              | REV. B<br>SHEET 1 OF 5 |
| DATE<br><b>06.05.23</b> |                                | TITLE<br><b>STEP LEG ASSEMBLY</b>                        | SCALE<br>1:2           |
| A                       | 02.09.11                       | NEW ISSUE  |                        |
| B                       | 06.05.23                       | ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5               |                        |

**RELEASED**

*06.06.20* *[Signature]*



**D3065-041 STEP LEG ASSEMBLY**

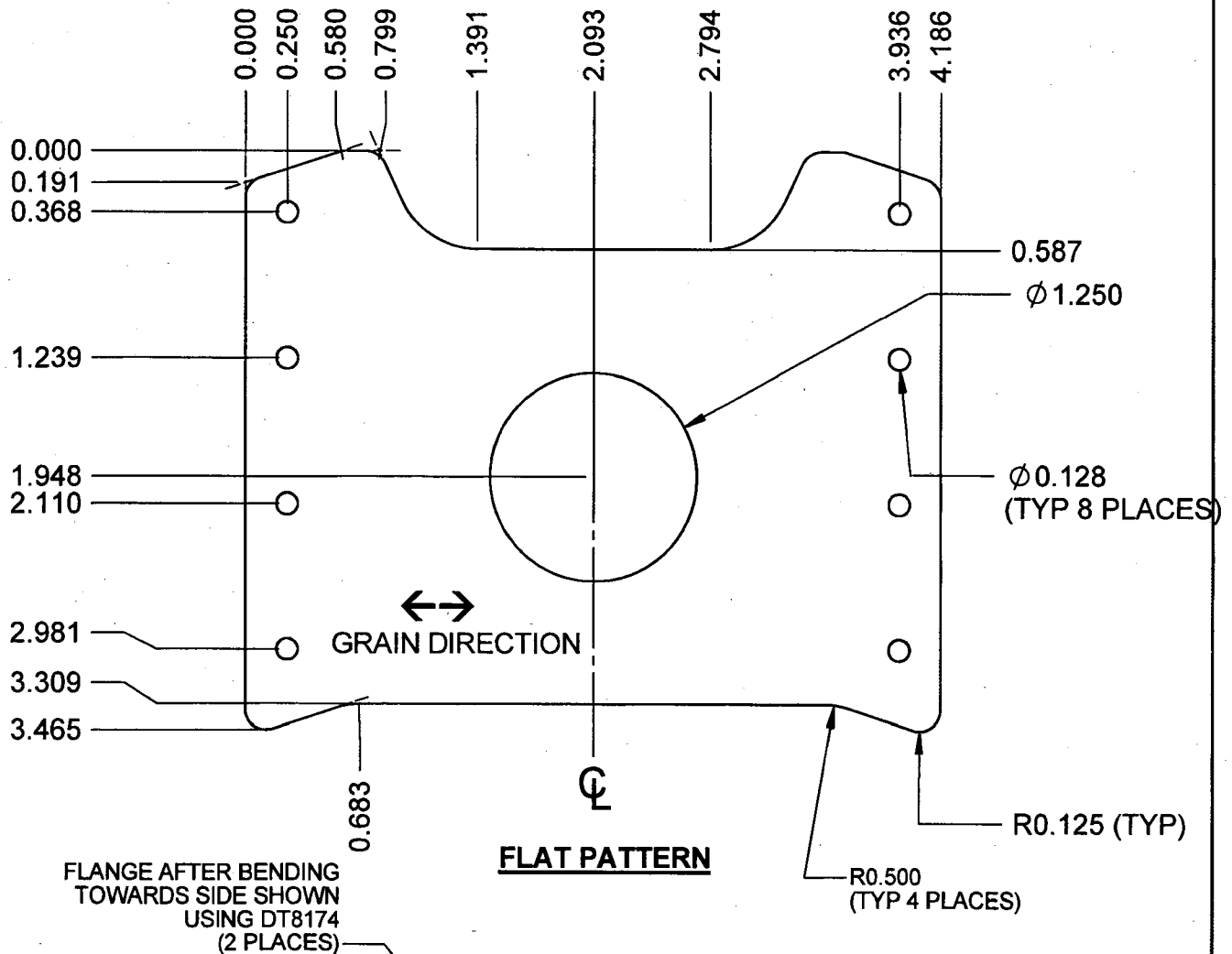
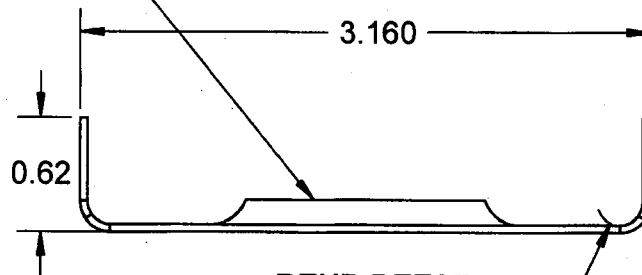
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *42344*

**COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

|                         |                       |  |                        |
|-------------------------|-----------------------|--|------------------------|
| DESIGN<br><i>CP</i>     | DRAWN BY<br><i>CB</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>PH</i>    | APPROVED<br><i>#</i>  | DRAWING NO.<br><b>D3065</b>                              | REV. B<br>SHEET 2 OF 5 |
| DATE<br><b>06.05.23</b> |                       | TITLE<br><b>STEP LEG ASSEMBLY</b>                        | SCALE<br>1:1           |

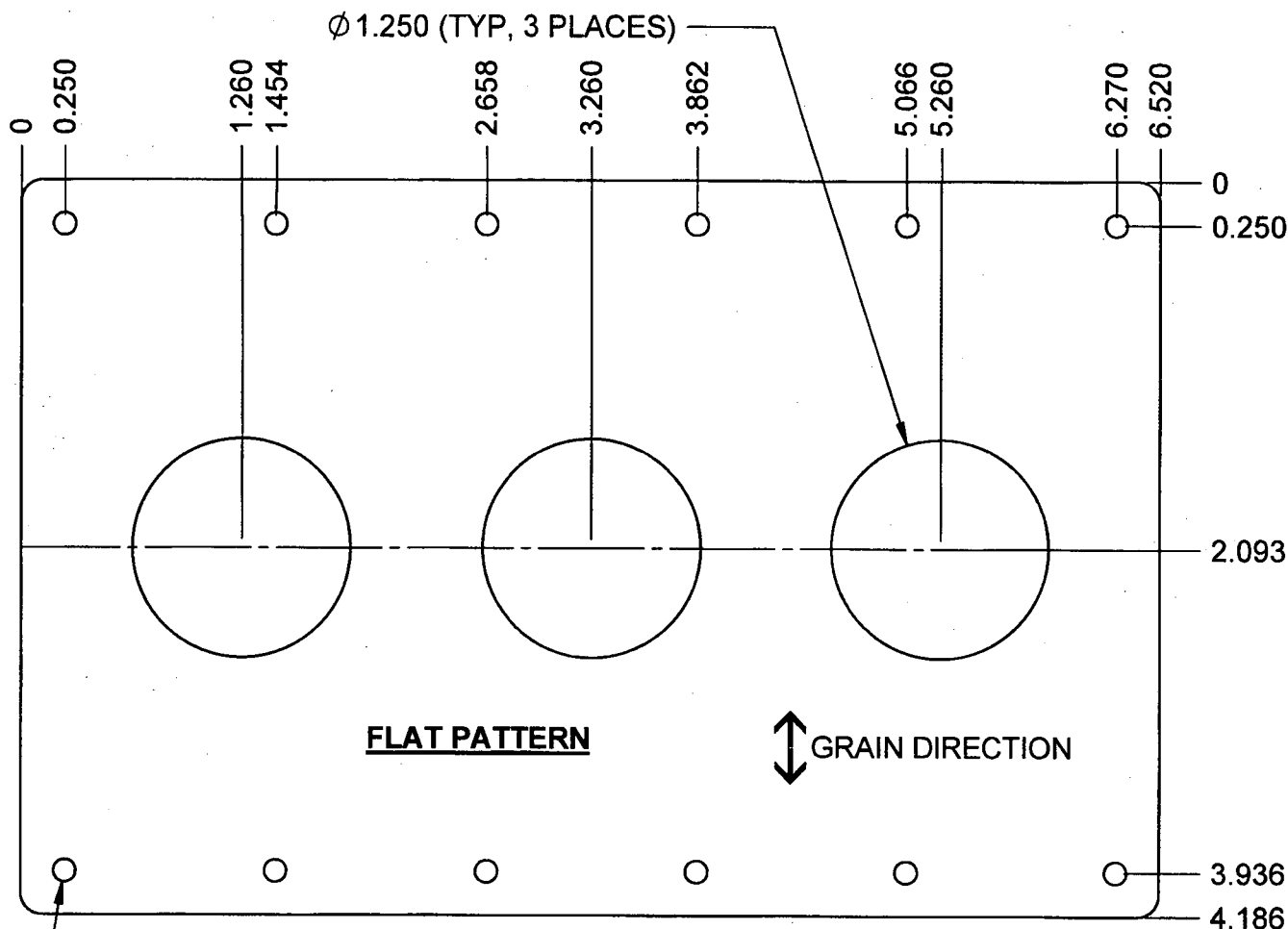
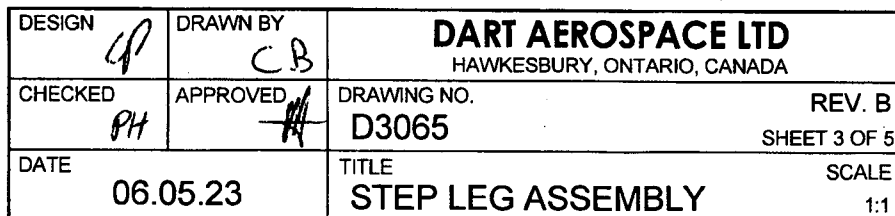
**RELEASED***cl de-ro #***D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *42344*

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

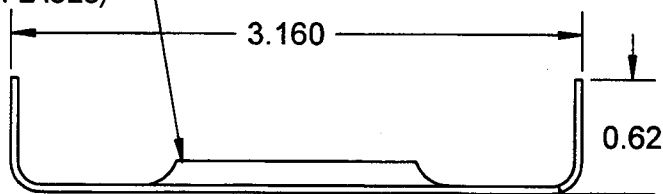


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

**RELEASED**

Ch. 20



### BEND DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4234

## D3065-3 STEP SPACER

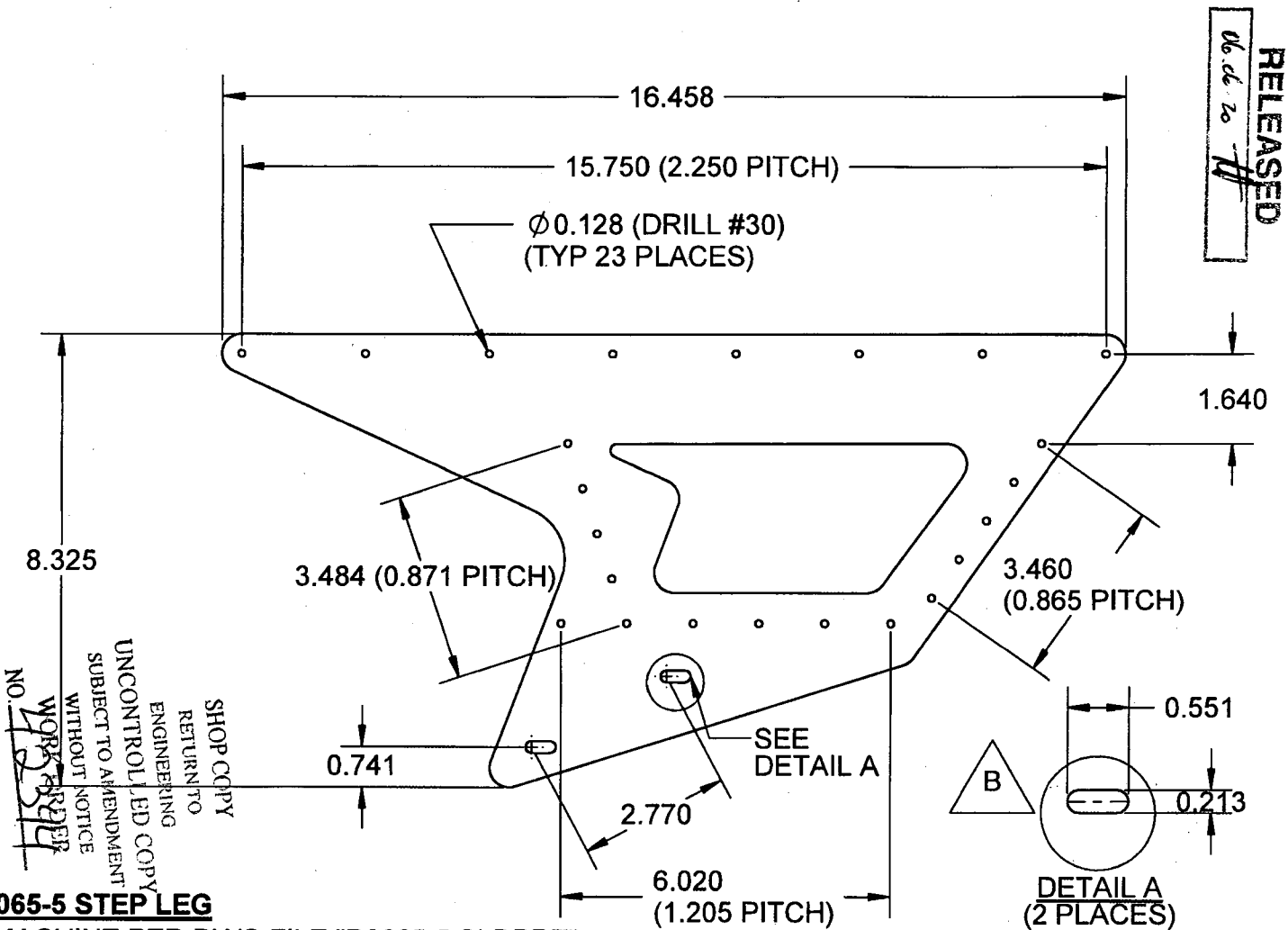
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

**COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

|          |          |                             |
|----------|----------|-----------------------------|
| DESIGN   | DRAWN BY | <b>DART AEROSPACE LTD</b>   |
| CHECKED  | APPROVED | HAWKESBURY, ONTARIO, CANADA |
| 04       | 04       | DRAWING NO. <b>D3065</b>    |
| DATE     |          | TITLE                       |
| 06.05.23 |          | <b>STEP LEG ASSEMBLY</b>    |
|          |          | REV. B                      |
|          |          | SHEET 4 OF 5                |
|          |          | SCALE                       |
|          |          | 1:3                         |



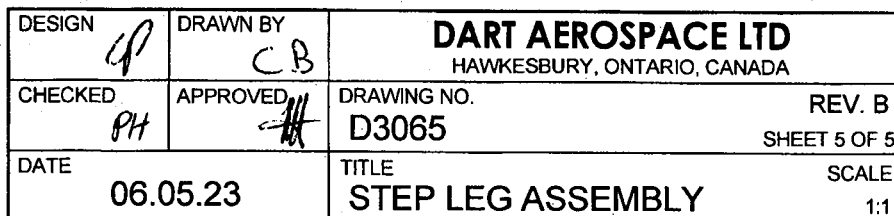
**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT ©2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





## FLAT PATTERN

**RELEASED**

OK OK 20 *[Signature]*

## BEND DETAIL

R0.125 (TYP)  
SHOP COPY  
RETURN TO  
ENGINEERING  
024T3S.040  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42374

## D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC  
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
3) PART IS SYMMETRIC ABOUT CENTERLINE  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

**COPYRIGHT © 2002 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.